

HiFill® PA6/6 GF25 FR-NR IM BK

 Techmer Polymer Modifiers - *Polyamide 66*
General Information

General			
Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Glass Fiber		
Additive	• Flame Retardant	• Impact Modifier	
Features	• Flame Retardant	• Halogen Free	• Impact Modified
Appearance	• Black		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.31		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	11000	psi	ASTM D638
Tensile Strength (Break)	12800	psi	ASTM D638
Tensile Elongation (Break)	5.5	%	ASTM D638
Flexural Modulus	800000	psi	ASTM D790
Flexural Strength	17000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	1.5	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	445	°F	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	ASTM D257
Volume Resistivity	1.0E+13	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	520	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.13 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.12	%
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	540 to 560	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	130 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi

Injection Notes


Screw Speed: Medium

Recommendations for Molding and Tool Conditions: Well vented

Moisture Content, as received: Product is packaged at 0.2% or less.

Recommended Max Moisture: 0.12% down to 0.08%

Notes

¹ Typical properties: these are not to be construed as specifications.

